

Date: Monday, 02/06/2008 4:39:06 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 39653B					
Estimate Number	: 10193					
P.O. Number	:			Part Number	: D2512	
This Issue	: 02/06/2008		S.O. No. :	Drawing Number	: D2512 UNDER REVIEW <i>03.06.03</i>	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D2	
Previous Run	: 39652B			Material	:	
Written By	:			Due Date	: 15/06/2008	
Checked & Approved By	: <i>SLP 08.06.02</i>			Qty:	1 Um: Each	
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF			Est Rev:N 06.04.05 Added level21	EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
		Pick: 3/4"x3/4" 304/316 SS tube <i>0.065</i> <i>0.06.03</i>	
		Batch: <i>M108153</i>	<i>SA0 08/06/13</i>
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D3166-3	Basket Hoop	<i>R38780</i> <i>SA0 08/06/16</i>
3.0	D2506	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D2506	Label Plate	<i>A37746</i>
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	2 D2327-1	Bushing	<i>D36920</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 39653B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D22321 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	<u>35684</u>

✓ FC 08 06 23

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	<u>139046</u>

✓ FC 08 06 23

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	<u>M107966</u>

SAO 08/06/19 ①

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

FC

2-Cut (4) D2236 From D3166-3

SAO

08/06/16

①

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

FC

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

FC 08 06 23 ①

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-24 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350/212/130 BASKET LID

Job Number: 39653B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC6 DIMENSIONAL CHECK



SO8/06/24 Q

Comment: DIMENSIONAL CHECK

11.0 POWDER COATING POWDER COATING



M107925.

Comment: POWDER COATING

Powder Coat White Gloss (Ref. A.85.1) as per QSI 005 4.3

Start Time: 6:35

Coat 2

Oven Temperature: 400°

7:15

Finish Time: 7:05

400°

7:45

FL 08/06/25

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Black M108340

Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M107893 FL 08-06-25

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP08/06/26 Q

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

EP08/06/26 Q

15.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/01 Q

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

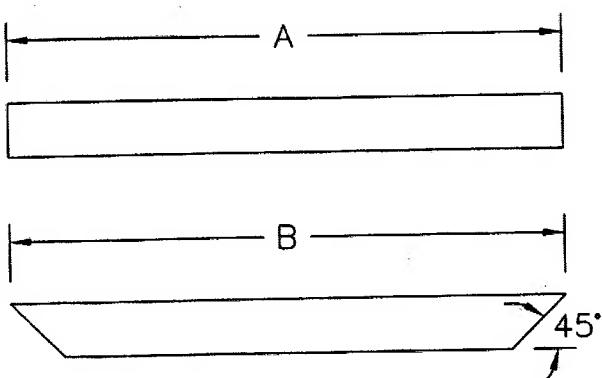
DESIGN BW	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE NTS

**RELEASED**  
01.04.27 *UP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	<i>UP</i> 03.01.20	ADD D2012-117 FOR D130-701-041
D2	<i>UP</i> 04.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



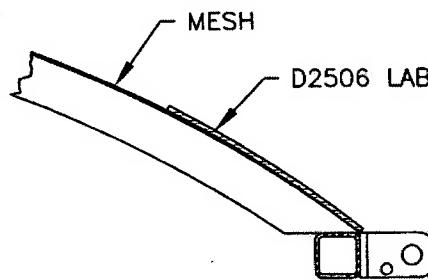
*08.06.03*  
**UNDER REVIEW**  
*08.02.05 ~~UP~~*  
 TUBING TUBE  
 CHANGED TO 0.065  
 WALL  
 SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *316530*

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST *0.065 08.06.03*  
 MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X *0.060* WALL SQUARE TUBING  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 ALL DIMENSIONS ARE IN INCHES

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D2506 LABEL PLATE (REF)

08-04-06-14  
TUBING TO BE  
CHANGED TO 0.055  
WALL  
0.055-0.03

**UNDER REVIEW**

SECTION A-A  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

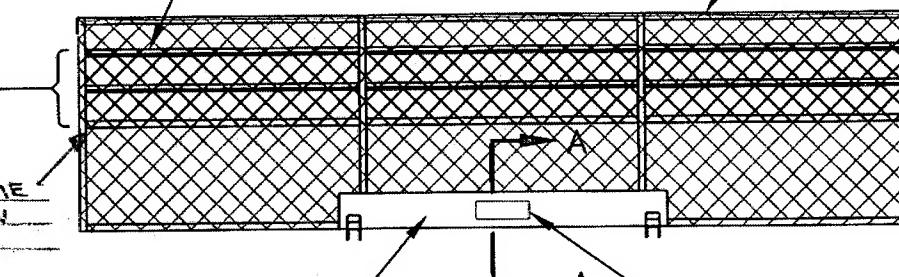
D2

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
TO BE ANTI-SKIDDED

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WORK ORDER  
34053B

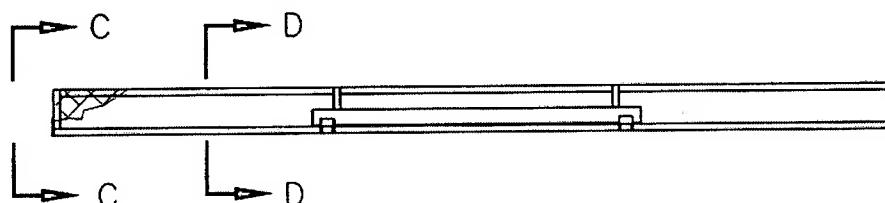
SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
01.04.19

**DART**

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DESIGN BW	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED A	APPROVED A	DRAWING NO. D2512
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	REV. D SHEET 2 OF 4 SCALE 1:20



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UNDER REVIEW  
08/05/03  
TUBING TO BE  
CHANGED TO 0.055  
WHILE PTFE  
03.06.03

RELEASER  
01-04-27  
WORK ORDER  
39165-3B

NOTICE OF A SUBJECT TO AMENDMENT  
WITHOUT NOTICE

RETURN TO  
ENGINEERING  
INSTITUTE

2012-117 CLEANS  
DD FOR D130-701-04  
NLT (2 PLATES)

A technical drawing showing a horizontal beam assembly. The beam is divided into three sections by vertical supports. Reference callouts point to the leftmost section with the label 'D2512-7 (REF)' and to the central support with the label 'D2236'. A dimension line below the beam indicates a total width of '30.63 (REF)' for the central section.

Technical drawing of a cabinet assembly. The top horizontal dimension is 95.30, with 0.00 above and -0.01 below. The left side shows two vertical sections labeled D2512-3 (2) and D2512-1 (2). The main cabinet body is divided into three horizontal sections. The middle section contains three vertical panels labeled D2512-5, D2512-7, and D2512-5. The width of the middle section is 30.62 (REF). The bottom horizontal dimension is 34.50, with 29.65 on each side and 34.50 in the center. The bottom right panel is labeled D2581 (2) and 13.76 (REF). A note on the left indicates 'ALL JOINTS AS SHOWN'. A 'TYP' symbol is present on the left side.

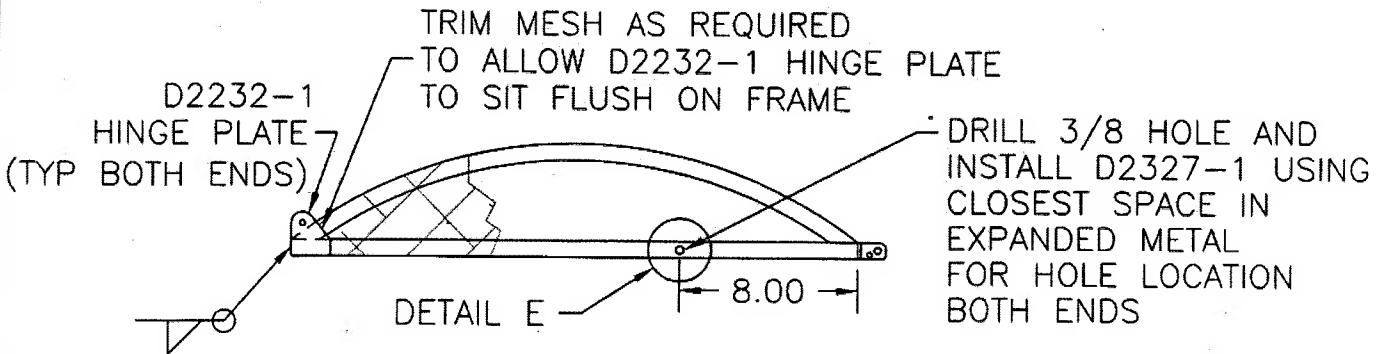
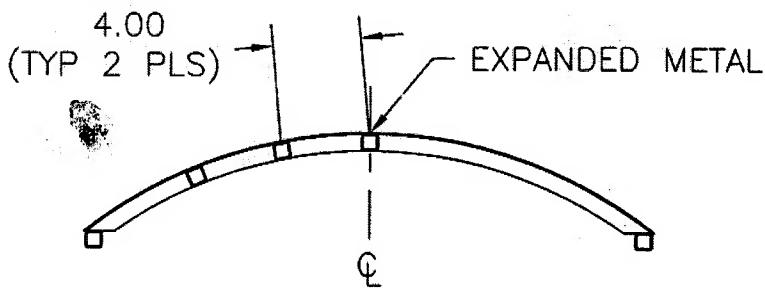
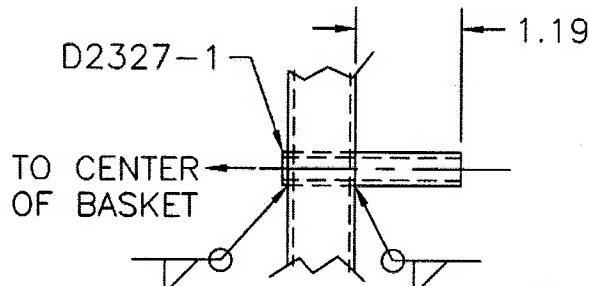
PLACES) DETAIL B  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

**DANIS**

		<b>DART AEROSPACE LTD</b>	
		HAWKESBURY, ONTARIO, CANADA	
DESIGN	REV. D		
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 4
DATE	TITLE	SCALE	
01.04.19	BASKET LID ASSEMBLY (350/212)	1:20	

**DART**DRAFTS  
G.COPY

DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

SECTION C-C SIMILAR BOTH END RIBS

RF 08.06.03  
**UNDER REVIEW**  
08-02-05 AM

TUBING TO BE  
CHANGED TO C.O.F.S.  
WALL

**RELEASED**  
01.04.27  
NO. 91053B

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